

Work Order ID 135370

Wednesday, August 12, 2015 4:25:43 PM

135370

Page 1

Item ID: D350-607-511

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Stop ***NS2***

Start Date: 8/11/15 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 8/19/15 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: AUG 13 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D350-607-4	C	
DSI9699	A	<i>*SP</i>

100	Document Control	0.00							DAS 38 9-89
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-511 CHG006								15-09-29

140	Pick Kit	0.00							
140									
Packaging	Memo	0.00							
Packaging									2X DAS 27 9-89 SEP 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 135370

Wednesday, August 12, 2015 4:25:43 PM

135370

Page 2

Item ID: D350-607-511 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH
 Start Date: 8/11/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/19/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC4- 100% Inspect kits for completeness	0.00							
150									
QC	Memo	0.00				2			DAS 38 9-89
Quality Control									15-09-29
160		0.00							
160	Packaging								DAS 02 9-89
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-511								SEP 29 2015
	Location: PK 14								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control						ML5			SEP 29 2015

ML5 SEP 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Wednesday, August 12, 2015 4:25:41 PM

Page 1

Work Order ID: 135370

135370

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 8/11/15

Required Date: 8/19/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP
REV:B 13.12.30 PER RE.C ECN13-672 DD VERF:RQ IPP REV:C
14.06.09 AS PER ECN14-572 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3910-7		Manufactured	No				Each	31.0000		2			
D3910-7	DAS 38 9-89								**			DAS 27 9-89	DAS 02 9-89
Crosstube Lug													
				<u>Location</u>				<u>Loc Qty</u>					
				ST524				30					
				133914				30		2			
				ST525				1					
				129734				1					
D3501-1	DAS 38 9-89	Manufactured	No			140	Each	37.0000	8	16			
D3501-1									**			DAS 27 9-89	DAS 02 9-89
Bushing													
				<u>Location</u>				<u>Loc Qty</u>					
				ST039				36					
				130742				14					
				131169				22		B13S9A 16			
				ST046				1					
				125925				1					
D3910-3	DAS 38 9-89	Manufactured	No			140	Each	39.0000	2	4			
D3910-3									**			DAS 27 9-89	DAS 02 9-89
X-Tube Lug													
				<u>Location</u>				<u>Loc Qty</u>					
				ST523				39					
				117781				39		5			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

Wednesday, August 12, 2015 4:25:41 PM

Page 2

Work Order ID: 135370

135370

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 8/11/15

Required Date: 8/19/15

Start Qty: 2.00

Required Qty: 2.00

D3910-5 Manufactured No 140 Each 30.0000 1 2

D3910-5

DAS
38
9-89

Crosstube Lug

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST524

30

134017

30

D3984 Manufactured No 140 f 85.0000 2 4

D3984

Rubber Extrusion, X-Tube, Per Foot

DAS
38
9-89

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST413

85

115196

10

132156

75

D4148-041 Manufactured No 140 Each 3.0000 1 2

D4148-041

Fwd Crosstube Lug Assembly

DAS
38
9-89

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST539

3

134473

2

134937

1

D4149-041 Manufactured No 140 Each 2.0000 1 2

D4149-041

Aft X-Tube Lug Ass'y

DAS
38
9-89

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST539

2

133978

2

SEP 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Picklist Print

Wednesday, August 12, 2015 4:25:42 PM

Work Order ID: 135370

135370

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 8/11/15

Required Date: 8/19/15

Start Qty: 2.00

Required Qty: 2.00

D4775-041

DAS
38
9-89

Manufactured No

140 Each 5.0000 2 4

D4775-041

Strut Assembly

DAS

DAS

27

02

9-89

9-89

Location

Loc Qty

Loc Code

ST514

5

132727

2

133493

2

133997

1

B135720

4

D4776-3

DAS
38
9-89

Manufactured No

140 Each 0.0000 2 4

D4776-3

Skidtube Clevis

DAS

DAS

27

02

9-89

9-89

AN4-14A

Purchased No

140 Each 187.0000 20 40

AN4-14A

Bolt

DAS

DAS

27

02

9-89

9-89

SEP 28 2015

Location

Loc Qty

Loc Code

FG

5

122141

5

ST325A

100

M132677

100

ST344

82

M132640

82

40

AN4-42A

Purchased No

140 Each 52.0000 4 8

AN4-42A

Bolt

DAS

DAS

27

02

9-89

9-89

SEP 28 2015

Location

Loc Qty

Loc Code

ST312A

40

M132551

40

ST342

12

M132317

12

D8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

Page 4

Wednesday, August 12, 2015 4:25:42 PM

Work Order ID: 135370

135370

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 8/11/15

Required Date: 8/19/15

Start Qty: 2.00

Required Qty: 2.00

AN6-13A Purchased No 140 Each 61.0000 2 4

AN6-13A
BOLT

DAS
38
9-89

**

DAS
02
9-89

Location Loc Qty Loc Code

ST286A 50
m132825 50
ST335 11
m132536 11

48

DAS
27
9-89

MS21042L4 Purchased No 140 Each 2,772.000 24

MS21042L4
Locknut

DAS
38
9-89

**

DAS
27
9-89
SEP 28 2015
DAS
02
9-89

Location Loc Qty Loc Code

FP001 2
m124231 2
GA 134
m127813 134
ST260a 170
m130799 56
m131803 6
m132262 108
ST305 2466
m128300 8
m128798 12
m130388 7
m130922 97
m131618 12
m132123 56
m132382 2274

48

Wednesday, August 12, 2015 4:25:42 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Page 5

Wednesday, August 12, 2015 4:25:42 PM

Work Order ID: 135370

135370

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 8/11/15

Required Date: 8/19/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L6

Purchased

No

140

Each

253.0000

2

4

MS21042L6

DAS

38

Nut

9-89

**

DAS

27

9-89

DAS

02

9-89

LocationLoc QtyLoc Code

ST260a

35

m132262

35

ST273A

200

~~m131624~~

200

ST305

1

m129909

1

t260a

17

m131317

17

NAS1149F0432P

Purchased

No

140

Each

1,062.000

40

80

NAS1149F0432P

DAS

38

WASHER

9-89

**

DAS

27

9-89

DAS

02

9-89

LocationLoc QtyLoc Code

ST260a

500

M132551

500

st268

562

M128995

63

M130388

8

M132677

491

NAS1149F0663P

Purchased

No

140

Each

228.0000

4

8

NAS1149F0663P

DAS

38

WASHER

9-89

**

DAS

27

9-89

DAS

02

9-89

LocationLoc QtyLoc Code

st268

228

M128591

2

M131317

26

M132823

200

Wednesday, August 12, 2015 4:25:42 PM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																													
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																														
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																														
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																														
Large Fab ☐	Composite ☐	Supplier ☐																																																																															
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																																																																													
Description Work Order Deviation			Disposition																																																																														
			Completed By																																																																														
			Lead hand / Supervisor Approval Verification																																																																														
			QC / QA Coordinator Approval																																																																														
<table style="width:100%; border: none;"> <tr> <td colspan="3" style="text-align: center; vertical-align: top;"> Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">☐ No Re-verification</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">☐ Operator</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">☐ Offset/Setup</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">☐ Supplier</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">☐ Training</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">☐ Use for Testing</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">☐ Poor Information</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">☐ Rushing</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">☐ Product Improvement</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">☐ Process Improvement</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">☐ Manufacturing Process</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">☐ Past Due</td></tr> </table> </td> <td colspan="3" style="text-align: center; vertical-align: top;"> FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">☐ Pressure/Forced</td><td style="border: none;">☐ Temperature/Cure</td><td style="border: none;">☐ Power Loss/Surge</td><td style="border: none;">☐ Positioned Wrong</td></tr> <tr><td style="border: none;">☐ Bending</td><td style="border: none;">☐ Set-up</td><td style="border: none;">☐ Folio/Program</td><td style="border: none;">☐ Outside Dimensions</td></tr> <tr><td style="border: none;">☐ Centre Not Concentric</td><td style="border: none;">☐ BOM/Route</td><td style="border: none;">☐ Grain</td><td style="border: none;">☐ Over/Under tolerance</td></tr> <tr><td style="border: none;">☐ Cracks</td><td style="border: none;">☐ Broken/Damage/Defect</td><td style="border: none;">☐ Weld</td><td style="border: none;">☐ Part Incorrect</td></tr> <tr><td style="border: none;">☐ Crimp/Kink/Ripple/Wave</td><td style="border: none;">☐ Inspection Incomplete/Unqualified</td><td style="border: none;">☐ Wrong Stock Pulled</td><td style="border: none;">☐ Part Lost/Missing</td></tr> <tr><td style="border: none;">☐ Cuffs</td><td style="border: none;">☐ Contamination</td><td style="border: none;">☐ Out of Sequence</td><td style="border: none;">☐ Part Moved</td></tr> <tr><td style="border: none;">☐ Crushing</td><td style="border: none;">☐ Countersink</td><td style="border: none;">☐ Off-set</td><td style="border: none;">☐ Drawing</td></tr> <tr><td style="border: none;">☐ Heat Treat</td><td style="border: none;">☐ Cut Too Short</td><td style="border: none;">☐ Mislabeled</td><td style="border: none;">☐ Finish</td></tr> <tr><td style="border: none;">☐ Wave/Twist in Tube</td><td style="border: none;">☐ Instructions Incomplete/Unclear</td><td style="border: none;">☐ Fit/Function</td><td style="border: none;">☐ Misread</td></tr> <tr><td style="border: none;">☐ Marks/Chatter</td><td style="border: none;">☐ Drill Holes</td><td style="border: none;">☐ Misaligned/off center</td><td style="border: none;">☐ Turning Sequence</td></tr> </table> </td> </tr> <tr> <td colspan="6" style="text-align: center;"> ☐ OTHER : _____ </td> </tr> </table>						Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">☐ No Re-verification</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">☐ Operator</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">☐ Offset/Setup</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">☐ Supplier</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">☐ Training</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">☐ Use for Testing</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">☐ Poor Information</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">☐ Rushing</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">☐ Product Improvement</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">☐ Process Improvement</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">☐ Manufacturing Process</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">☐ Past Due</td></tr> </table>			Environment ☐	☐ No Re-verification	Design ☐	☐ Operator	Doc/Data ☐	☐ Offset/Setup	Equip/Tooling ☐	☐ Supplier	Handling/Pre ☐	☐ Training	Material ☐	☐ Use for Testing	Internal Transport ☐	☐ Poor Information	Tribal Knowledge ☐	☐ Rushing	LOA ☐	☐ Product Improvement	Substation ☐	☐ Process Improvement	Past Expiry Date ☐	☐ Manufacturing Process	Misidentified ☐	☐ Past Due	FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">☐ Pressure/Forced</td><td style="border: none;">☐ Temperature/Cure</td><td style="border: none;">☐ Power Loss/Surge</td><td style="border: none;">☐ Positioned Wrong</td></tr> <tr><td style="border: none;">☐ Bending</td><td style="border: none;">☐ Set-up</td><td style="border: none;">☐ Folio/Program</td><td style="border: none;">☐ Outside Dimensions</td></tr> <tr><td style="border: none;">☐ Centre Not Concentric</td><td style="border: none;">☐ BOM/Route</td><td style="border: none;">☐ Grain</td><td style="border: none;">☐ Over/Under tolerance</td></tr> <tr><td style="border: none;">☐ Cracks</td><td style="border: none;">☐ Broken/Damage/Defect</td><td style="border: none;">☐ Weld</td><td style="border: none;">☐ Part Incorrect</td></tr> <tr><td style="border: none;">☐ Crimp/Kink/Ripple/Wave</td><td style="border: none;">☐ Inspection Incomplete/Unqualified</td><td style="border: none;">☐ Wrong Stock Pulled</td><td style="border: none;">☐ Part Lost/Missing</td></tr> <tr><td style="border: none;">☐ Cuffs</td><td style="border: none;">☐ Contamination</td><td style="border: none;">☐ Out of Sequence</td><td style="border: none;">☐ Part Moved</td></tr> <tr><td style="border: none;">☐ Crushing</td><td style="border: none;">☐ Countersink</td><td style="border: none;">☐ Off-set</td><td style="border: none;">☐ Drawing</td></tr> <tr><td style="border: none;">☐ Heat Treat</td><td style="border: none;">☐ Cut Too Short</td><td style="border: none;">☐ Mislabeled</td><td style="border: none;">☐ Finish</td></tr> <tr><td style="border: none;">☐ Wave/Twist in Tube</td><td style="border: none;">☐ Instructions Incomplete/Unclear</td><td style="border: none;">☐ Fit/Function</td><td style="border: none;">☐ Misread</td></tr> <tr><td style="border: none;">☐ Marks/Chatter</td><td style="border: none;">☐ Drill Holes</td><td style="border: none;">☐ Misaligned/off center</td><td style="border: none;">☐ Turning Sequence</td></tr> </table>			☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	☐ OTHER : _____					
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">☐ No Re-verification</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">☐ Operator</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">☐ Offset/Setup</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">☐ Supplier</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">☐ Training</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">☐ Use for Testing</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">☐ Poor Information</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">☐ Rushing</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">☐ Product Improvement</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">☐ Process Improvement</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">☐ Manufacturing Process</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">☐ Past Due</td></tr> </table>			Environment ☐	☐ No Re-verification	Design ☐	☐ Operator	Doc/Data ☐	☐ Offset/Setup	Equip/Tooling ☐	☐ Supplier	Handling/Pre ☐	☐ Training	Material ☐	☐ Use for Testing	Internal Transport ☐	☐ Poor Information	Tribal Knowledge ☐	☐ Rushing	LOA ☐	☐ Product Improvement	Substation ☐	☐ Process Improvement	Past Expiry Date ☐	☐ Manufacturing Process	Misidentified ☐	☐ Past Due	FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">☐ Pressure/Forced</td><td style="border: none;">☐ Temperature/Cure</td><td style="border: none;">☐ Power Loss/Surge</td><td style="border: none;">☐ Positioned Wrong</td></tr> <tr><td style="border: none;">☐ Bending</td><td style="border: none;">☐ Set-up</td><td style="border: none;">☐ Folio/Program</td><td style="border: none;">☐ Outside Dimensions</td></tr> <tr><td style="border: none;">☐ Centre Not Concentric</td><td style="border: none;">☐ BOM/Route</td><td style="border: none;">☐ Grain</td><td style="border: none;">☐ Over/Under tolerance</td></tr> <tr><td style="border: none;">☐ Cracks</td><td style="border: none;">☐ Broken/Damage/Defect</td><td style="border: none;">☐ Weld</td><td style="border: none;">☐ Part Incorrect</td></tr> <tr><td style="border: none;">☐ Crimp/Kink/Ripple/Wave</td><td style="border: none;">☐ Inspection Incomplete/Unqualified</td><td style="border: none;">☐ Wrong Stock Pulled</td><td style="border: none;">☐ Part Lost/Missing</td></tr> <tr><td style="border: none;">☐ Cuffs</td><td style="border: none;">☐ Contamination</td><td style="border: none;">☐ Out of Sequence</td><td style="border: none;">☐ Part Moved</td></tr> <tr><td style="border: none;">☐ Crushing</td><td style="border: none;">☐ Countersink</td><td style="border: none;">☐ Off-set</td><td style="border: none;">☐ Drawing</td></tr> <tr><td style="border: none;">☐ Heat Treat</td><td style="border: none;">☐ Cut Too Short</td><td style="border: none;">☐ Mislabeled</td><td style="border: none;">☐ Finish</td></tr> <tr><td style="border: none;">☐ Wave/Twist in Tube</td><td style="border: none;">☐ Instructions Incomplete/Unclear</td><td style="border: none;">☐ Fit/Function</td><td style="border: none;">☐ Misread</td></tr> <tr><td style="border: none;">☐ Marks/Chatter</td><td style="border: none;">☐ Drill Holes</td><td style="border: none;">☐ Misaligned/off center</td><td style="border: none;">☐ Turning Sequence</td></tr> </table>			☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence												
Environment ☐	☐ No Re-verification																																																																																
Design ☐	☐ Operator																																																																																
Doc/Data ☐	☐ Offset/Setup																																																																																
Equip/Tooling ☐	☐ Supplier																																																																																
Handling/Pre ☐	☐ Training																																																																																
Material ☐	☐ Use for Testing																																																																																
Internal Transport ☐	☐ Poor Information																																																																																
Tribal Knowledge ☐	☐ Rushing																																																																																
LOA ☐	☐ Product Improvement																																																																																
Substation ☐	☐ Process Improvement																																																																																
Past Expiry Date ☐	☐ Manufacturing Process																																																																																
Misidentified ☐	☐ Past Due																																																																																
☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong																																																																														
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions																																																																														
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance																																																																														
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect																																																																														
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																																																														
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved																																																																														
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing																																																																														
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish																																																																														
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread																																																																														
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence																																																																														
☐ OTHER : _____																																																																																	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

15-08-13
NO 135370
MCS
UNCONTROLLED COPY
ENGINEER
SUBJECT TO A CHANGE
WITHIN THE DART
WORK ORDER

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

- 3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.
- 3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole.
Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).
- 3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

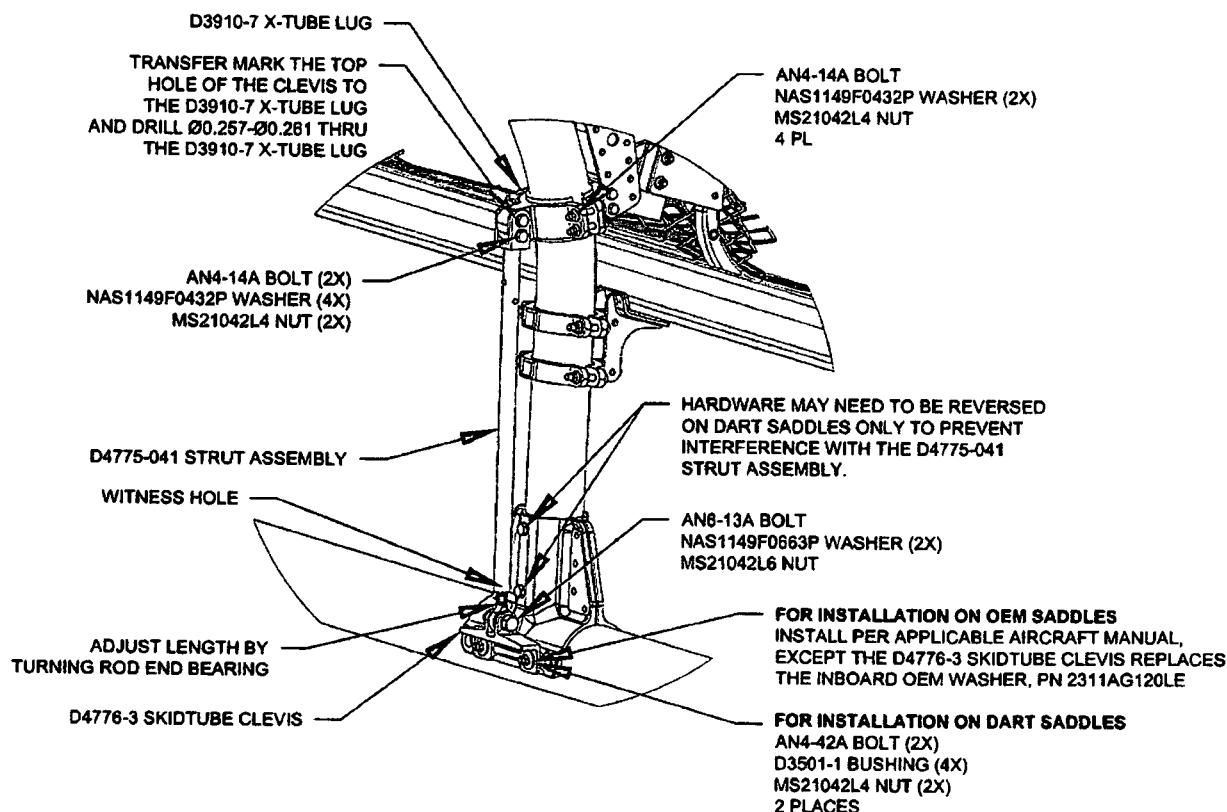


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

5.0 PARTS LIST

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
			X	D350-607-431	STRUT RETROFIT KIT
		8	8	D3501-1	BUSHING
		2		D3910-3	X-TUBE LUG
		2	2	D3910-5	X-TUBE LUG
1				D3912-041	EYEBOLT RECEIVER ASSY
4				D3917-3	WASHER
		8	4	D3984-030	RUBBER EXTRUSION, X-TUBE
		1		D4148-041	FWD X-TUBE LUG ASSY
		1		D4149-041	AFT X-TUBE LUG ASSY
1				D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
		2	2	D4775-041	STRUT ASSEMBLY
		2	2	D4776-3	SKIDTUBE CLEVIS
1				D4874-041	CARGO TUBE ASSEMBLY
1				D4875-043	CARGO TUBE AFT STRUT
1				D4875-045	FWD ATTACHMENT CLEVIS
			1	D4917-300	PLACARD MAX LOAD
			1	D4917-310	PLACARD MAX LOAD
			1	D4917-315	PLACARD, MAX LOAD
			1	D4917-320	PLACARD, MAX LOAD
			1	D4917-332	PLACARD, MAX LOAD
1				D5028-041	PLUG ASSEMBLY
1				D5031-041	LOCK PIN ASSY
2				AN310-4	CASTLE NUT
2				AN4-11	BOLT
4				AN4-13A	BOLT
		20	12	AN4-14A	BOLT
		4	4	AN4-42A	BOLT
		2	2	AN6-13A	BOLT
4	24	16		MS21042L4	NUT
	2	2		MS21042L6	NUT
2				MS24665-151	COTTER PIN
20	40	24		NAS1149F0432P	WASHER
		4	4	NAS1149F0663P	WASHER

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	N/A	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	